

# Work Order ID 73425

Wednesday, August 31, 2011 3:17:22 PM



Page 1

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 8/31/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/09/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9467	Rev A								
IIN D206-642	Rev N								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-512 CHG004

8 w/ 10/12

11/9/15 BG 11-9-15

110

0.00



Pick Kit

Memo

0.00

Packaging

Packaging

11/9/15 sl 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73425**

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Page 2

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 8/31/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/12

FC

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-512 Location: BK

Rau A

11/12/12

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/12

MR

11-09-22

W/O:		WORK ORDER CHANGES					
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Wednesday, August 31, 2011 3:17:18 PM

Page 1

Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 05.06.07 new issue EC  
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A		Purchased	No			110	Each	65.0000	3	12			
---------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--



BOLT

Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
18914	4	
ST352	16	
117366	16	
ST353	45	
117872	25	
118628	20	

AN3C36A		Purchased	No			110	Each	138.0000	9	36			
---------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--



BOLT

Location	Loc Qty	Loc Code
----------	---------	----------

FG	14	
101261	4	
116590	10	
FP-B	17	
111925	17	
ST353	107	
118191	22	
118451	20	
118706	15	
118757	50	

20  
16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN3C41A

Purchased

No

110

Each

98.0000

8

32



BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

94

117950

19

118518

50

118757

25

AN4C6A

Purchased

No

110

Each

349.0000

12

48



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

345

116704

15

117872

30

118191

100

118451

200

AN5C11A

Purchased

No

110

Each

164.0000

8

32



Bolt

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

110

117872

40

118706

70

ST338

50

118191

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN5C12A

Purchased

No

110

Each

67.0000

4



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

65

117313

15

118451

50

AN5C13A

Purchased

No

110

Each

84.0000

4



BOLT

Location

Loc Qty

Loc Code

FG

4

18918

4

ST338

80

117313

30

117872

50

AN5C15A

Purchased

No

110

Each

95.0000

1



Bolt

Location

Loc Qty

Loc Code

ST338

23

118191

23

ST339

72

117885

22

118267

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Wednesday, August 31, 2011 3:17:18 PM

Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN5C32A

Purchased

No

110

Each

91.0000

2



8/31/11

8/31

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

87

116380

37

117407

25

117969

25

8

AN5C34A

Purchased

No

110

Each

48.0000

2



8/31/11

8/31

Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

46

117763

21

117950

25

8

AN5C35A

Purchased

No

110

Each

61.0000

1



8/31/11

8/31

Location

Loc Qty

Loc Code

ST340

36

108407

36

ST341

25

118451

25

8

AN960C10L

NAS1149C0332  
R

Purchased

No

110

Each

0.0000

24

96



washer

11/18/11 11/15/11 5/14/11

8/31

Wednesday, August 31, 2011 3:17:19 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 31, 2011 3:17:19 PM

Page 5

Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN960C416L Purchased No

110 Each

0.0000

24 96

WASHER  
AN960C516L NAS1149C0532 Purchased No

110 Each

0.0000

8 32

D206-648-013 216002 Manufactured No

110 Each

8.0000

1

GHW Modification

## Location

## Loc Qty

## Loc Code

FG120

8

71578

2

72961

6

D2652 Manufactured No

110 Each

255.0000

16 64

Bushing

## Location

## Loc Qty

## Loc Code

FG

44

31985

44

ST

201

53741

0

72120

201

ST019

10

71833

10

Wednesday, August 31, 2011 3:17:19 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 6

Wednesday, August 31, 2011 3:17:19 PM

Work Order ID: 73425



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2712

Manufactured No

110 Each

531.0000 10



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

481

71160

181

72231

300

D2932-2

Manufactured No

110 Each

9.0000



Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

1

72515

1

ST428

8

71866

8

D2933-2

Manufactured No

110 Each

13.0000



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

8

72883

8

ST428

5

70876

5

Wednesday, August 31, 2011 3:17:19 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 7

Wednesday, August 31, 2011 3:17:19 PM

Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2934  
Saddle Spacer

Manufactured No

110 Each

33.0000

2

8

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

27

70772

27

D2935  
Saddle Spacer

Manufactured No

110 Each

25.0000

2

8

Location

Loc Qty

Loc Code

ST027

25

70770

25

D2938-2  
Saddle RH Out, 206

Manufactured No

110 Each

9.0000

1

4

Location

Loc Qty

Loc Code

ST421

1

71059

1

ST428A

8

71874

8

D2939-2  
Saddle RH In, 206

Manufactured No

110 Each

11.0000

1

4

Location

Loc Qty

Loc Code

ST428A

6

72885

6

ST429

5

70877

5

Wednesday, August 31, 2011 3:17:19 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 8

Wednesday, August 31, 2011 3:17:19 PM

Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

D3396-3

Manufactured No

110 Each

11.0000

2

8



Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

1

70983

1

D3407-043

Manufactured No

110 Each

8.0000

1

4



Tow Ring

Location

Loc Qty

Loc Code

ST463

6

70982

5

72513

1

ST464

2

68339

2

D3456-1

Manufactured No

110 Each

51.0000

1

4



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

44

66848

3

71165

41

Wednesday, August 31, 2011 3:17:19 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 9

Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

D3457-1

Manufactured No

110 Each

56.0000

2



Washer



8

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

46

67779

1

71849

45

8

D3672-1

Manufactured No

110 Each

1,178.000

24



Phenolic Washer



96

Location

Loc Qty

Loc Code

ST074

1176

64177

180

66821

496

72229

500

ST077

2

52505

2

96

D3672-3

Manufactured No

110 Each

767.0000

24



Phenolic Washer



96

Location

Loc Qty

Loc Code

ST074

767

64176

225

71159

42

72230

500

15

81

Wednesday, August 31, 2011 3:17:20 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

D3672-7 Manufactured No

110 Each

414.0000 24



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

414

53237

244

64175

170

MS21043-3

Purchased No

110 Each

1,337.000 20



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1265

112314

6

118077

259

118614

500

118686

500

MS21043-4

Purchased No

110 Each

1,372.000 13



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1332

117793

476

118378

356

118686

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 11

Wednesday, August 31, 2011 3:17:20 PM

Work Order ID: 73425

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

110

Each

504.0000

4

16



Nut



11/9/13

4

## Location

## Loc Qty

## Loc Code

FG

20

101418

20

ST301

384

112314

284

116548

100

ST314

100

118159

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP <sup>(1)</sup>
4					2			2		AN3C4A	* BOLT <sup>(1)</sup>
5A					2			2		NAS1149C0332R	* WASHER <sup>(1)</sup> (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET <sup>(1)</sup>
23A					1	1				D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET <sup>(1)</sup>
24A					1	1				D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET <sup>(1)</sup>
25A					1	1				D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET <sup>(1)</sup>
26A			8	8	78	78	8			AN3C4A	* BOLT <sup>(1)</sup>
26B			8	8	78	78	8			NAS1149C0332R	* WASHER <sup>(1)</sup> (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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Revision: 0

Date: 11.06.15

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE  
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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